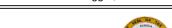
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150

Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/Ala Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-009069 Address: 333 Burma Road **Date Inspected:** 05-Sep-2009

City: Oakland, CA 94607

Project Name: SAS Superstructure OSM Arrival Time: 1900 **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Li Hong Fei No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: OBG** and Tower Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA inspector randomly observed the following work in progress in the trial assembly area:

5AE - ABF performing MT and grinding at the deck panel diaphragm to upper floor beam welds in the corner assembly areas, north and south.

3BW, east of panel point 23, ZPMC workers installing wire clips onto 10mm wire on the traveler rails. This QA inspector observed the workers installing the wire clips backwards, in a manner not recommended by the wire manufacturer.

Bay 11

This QA inspector randomly observed the following work in progress in Bay 11:

FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 85.25. Welder was identified as 070212. ZPMC QC was identified as CWI Li Hong Fei (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and WPS-B-T-2331-Tc-P4-F for weld joint 80.

WELDING INSPECTION REPORT

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FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 92.5. Welder was identified as 066471. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and WPS-B-T-2331-Tc-P4-F for weld joint 80.

FCAW welding of weld joints ESTL3-4B/K-79, 80 located on east tower, lift 3, skins B/C at diaphragm 95.5. Welder was identified as 068206. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P4-F for weld joint 79 and WPS-B-T-2331-Tc-P4-F for weld joint 80.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

This QA inspector informed day shift Caltrans QA personnel of the wire clips being installed backwards as noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer